

FIELD OF THE INVENTION

BACKGROUND OF THE INVENTION

Also as an attempt to make the separator conductive, various methods have been proposed, such as kneading or mixing of carbon fibers or particles, and compounding with graphite powder. Moreover, by using monomer such as

B' *und*
pyrrole, thiophen or aniline, a method of forming a
conductive high polymer on the surface by chemical
oxidation and polymerization is disclosed (see Japanese
Laid-open Patent No. 64-90517).

In the conventional constitution, however, there was a
limit in enhancement of conductivity of electrolyte, and
its conductivity is at most about ten to scores of mS/cm at
the present, and electrolyte having a sufficient
conductivity is not developed yet, and an electrolytic
capacitor of an electrolyte having a sufficient impedance
characteristic is not obtained so far.

On the other hand, for decrease of resistance of
separator, it has been attempted to decrease the separator
thickness, lower the density, make uniform the pore size,
or change from paper to high polymer nonwoven fabric, but
due to lack of strength by lowering of density and other
problems, a sufficient effect of lowering the resistance is
not obtained yet.

Further, the separator made conductive by kneading or
mixing carbon fibers or particles is not sufficient in the
electric conductivity, and it was hard to obtain a
separator of low density. When using a separator by
compounding graphite powder, there was a problem of
increase of shorting due to drop of graphite powder and
dispersion into electrolyte.

On the other hand, in the method of forming a conductive high polymer on the surface by chemical oxidation and polymerization from monomer of pyrrole, thiophen or aniline, it is difficult to compose an electrolytic capacitor of which rated voltage exceeds 35 V because there is almost no effect of deterioration of dielectric oxide film by oxidizing agent or chemical formation of conductive high polymer (defect repairing capability of dielectric oxide film). If composed, however, increase of leak current or shorting between anode and cathode may occur during agent process or high temperature test.

It is hence an object of the invention to present an electrolytic capacitor of high dielectric strength excellent in impedance characteristic, leak current property and reliability.

SUMMARY OF THE INVENTION

An electrolytic capacitor of the invention comprises:

(a) a capacitor element having an anode, a cathode, and a solid organic conductive material disposed between the anode and the cathode,

(b) an electrolyte,

(c) a case for accommodating the capacitor element and the electrolyte, and

(d) a sealing member disposed to cover the opening of the case.

A manufacturing method of electrolytic capacitor of the invention comprises:

- END
B2
- (a) a step of fabricating an anode,
 - (b) a step of fabricating a cathode,
 - (c) a step of forming a solid organic conductive material on the surface of the anode, and
 - (d) a step of disposing an electrode between the anode having the solid organic conductive material and the cathode.

In this constitution, an electrolytic capacitor having an excellent impedance characteristic, an excellent leak current characteristic, an excellent reliability, and a high dielectric strength is obtained.

BRIEF DESCRIPTION OF THE DRAWINGS

Fig. 1 (a) is a partial sectional perspective view showing a constitution of an electrolytic capacitor according to a first embodiment of the invention.

Fig. 1 (b) is a schematic diagram magnifying the essential parts of the electrolytic capacitor element shown in Fig. 1 (a).

Fig. 2 is a manufacturing process diagram for manufacturing the anode foil of an electrolytic capacitor

of the invention.

REFERENCE NUMERALS

- 1 Anode foil
- 2 Solid organic conductive material
- 3 Cathode foil
- 5 Anode lead
- 6 Cathode lead
- 7 Sealing member
- 8 Metallic case
- 9 Outer tube
- 10 Electrolyte
- 11 Dielectric oxide film
- 21 Aluminum foil
- 22 Etching foil
- 23 Solution containing polymerizable monomer
- 24 Heating oven

DETAILED DESCRIPTION OF THE INVENTION

An electrolytic capacitor of the invention comprises a case having an opening, an electrolyte contained in the case, a capacitor element placed in the electrolyte, and a sealing member disposed to cover the opening. The capacitor element has an anode, a cathode, and a solid organic conductive material installed between the anode and

cathode.

In this constitution, by making use of the high electric conductivity of the solid organic conductive material, the interpolar resistance in the conductive portion can be extremely decreased, and hence the impedance characteristic is enhanced. Further, by using together with the electrolyte having the repair capability of dielectric oxide film of valve action metal, an electrolytic capacitor of low leak current having a high dielectric strength is obtained.

In the invention, as the solid organic conductive material, an organic semiconductor is preferred, and preferred examples of organic semiconductor include 7,7,8,8-tetra-cyanoquinodimethane complex and its derivatives (hereinafter called TCNQ complexes). In this constitution, by dissolving and impregnating TCNQ complexes, a layer of solid organic conductive material having a high conductivity may be filled sufficiently to the inside of the pit of the anode processed by etching. As a result, an electrolytic capacitor excellent in impedance characteristic particularly in a high frequency region over 100 kHz can be obtained. Still more, TCNQ complexes can be directly applied on a separator base material. Moreover, a capacitor element winding an anode foil and a cathode foil through a separator base material can be manufactured.

Alternatively, a capacitor element laminating one set or two sets or more of anode and cathode through separator base material may be impregnated in a heated and dissolved TCNQ complex solution, and by cooling and solidifying, the conductivity may be easily expressed. As a result, an electrolytic capacitor having an excellent impedance characteristic may be easily obtained.

In the invention, the word of "anode" means "positive electrode", and the word of "cathode" means "negative electrode". The word of "conductive high polymer" means "conductive polymer".

In the invention, the conductive high polymer includes pyrrole, aniline, thiophen, ethylene dioxythiophen, sulfonated aniline, sulfonated pyrrole, sulfonated thiophen, sulfonated ethylene dioxythiophen, their derivatives, and polymers of various polymerizable monomers.

Methods of forming such polymers include a method by liquid-phase chemical polymerization, a method by vapor-phase chemical polymerization, a method by liquid-phase electrolytic polymerization, and a method by drying soluble high polymer solution and utilizing residual high polymer.

Usable examples of conductive high polymer include polypyrrole, polyethylene dioxythiophen, or polyaniline formed by chemical polymerization or electrolytic polymerization, and dry residual sulfonated polyaniline

obtained by drying solutions of soluble polyanilines.

In liquid-phase polymerization, in a solution containing at least the polymerizable monomer and a proper oxidizing agent, a capacitor element is immersed, and polymerized. In the case of an electrolytic polymerization, in a solution containing at least the polymerizable monomer and a proper oxidizing agent, a capacitor element is immersed, and power is supplied to polymerize it. In the case of vapor-phase polymerization, in a solution containing at least a proper oxidizing agent, a capacitor element is immersed (or immersed, lifted and dried), and then in the vapor phase containing at least the polymerizable monomer, the capacitor element is placed. By these methods, a layer of solid organic conductive material having a high conductivity can be sufficiently applied into the inside of pits of the anode processed by etching. As a result, an electrolytic capacitor having an excellent impedance characteristic also in a high frequency region of over 100 kHz in particular is obtained. Moreover, by polymerizing the conductive high polymer directly in the separator base material, anode or cathode in vapor phase, the conductivity can be easily expressed. As a result, an electrolytic capacitor having an excellent impedance characteristic may be easily obtained.

Further, since these conductive high polymers have a

electrolytic substance, at least one is used as being selected from the group consisting of compound having alkyl substituent amidine group, quaternary salt of compound having alkyl substituent amidine group, tertiary amine and ammonium. In this constitution, leak of electrolyte is prevented, and a capacitor of enhanced reliability is obtained.

When composing a capacitor by using an electrolyte composed of an electrolytic substance of a base of a strong basicity of which hydrogen ion concentration is less than 1.0×10^{-13} mol/dm³ (for example, tetra-alkyl ammonium or tetra-alkyl phosphonium), in long-term environmental test in the compound environments of high temperature and high humidity (for example, 60°C and 95% RH), the sealing member is likely to be damaged by the effects of the base of strong basicity, and leak is likely to occur, and the reliability is slightly inferior.

As the base for composing the electrolytic substance, at least one is preferred to be used as being selected from the group consisting of compound having alkyl substituent amidine group, quaternary salt of compound having alkyl substituent amidine group, tertiary amine and ammonium. In these electrolytic substances, when the concentration of the base or hydroxide of base is 1 wt.% and the measuring temperature is 30 °C, the hydrogen ion concentration in

aqueous solution of base or hydroxide of base is 1.0×10^{-13} mol/dm³ or more. Accordingly, the leak due to such strong acidity as mentioned above is less likely to occur.

As the quaternary salt of compound having alkyl substituent amidine group, a quaternary compound formed by alkyl group or aryl alkyl group with 1 to 11 carbon atoms is preferred, and such compound is one selected from the group consisting of imidazole compound, benzoimidazole compound, and alicyclic amidine compound. In this constitution, when hydroxide ions are formed by electrolytic reaction in the electrolyte, since the reaction between hydroxide ion and amidine group of N-C-N or reaction of decomposition and ring opening is fast, the electrolytic products disappear quickly. As a result, even in the condition of high temperature and high humidity, leak of electrolyte to outside can be prevented.

The quaternary salt of compound having alkyl substituent amidine group is at least one selected from the group consisting of 1-methyl-1,8-diazabicyclo [5,4,0] undecene-7, 1-methyl-1,5-diazabicyclo [4;3,0] nonene-5, 1,2,3-trimethyl imidazolinium, 1,2,3,4-tetramethyl imidazolinium, 1,2-dimethyl-3-ethyl-imidazolinium, 1,3,4-trimethyl-2-ethyl imidazolinium, 1,3-dimethyl-2-heptyl imidazolinium, 1,3-dimethyl-2-(-3' heptyl) imidazolinium, 1,3-dimethyl-2-dodecyl imidazolinium, 1,2,3-trimethyl-

1,4,5,6-tetrahydropyrimidium, 1,3-dimethyl imidazolium, 1-methyl-3-ethyl-imidazolium, and 1,3-dimethyl benzoimidazolium. According to this constitution, the conductivity of the electrolyte can be heightened and an excellent heat resistance is realized. Therefore, external leak of electrolyte at high temperature and high humidity is prevented, and an electrolytic capacitor having an excellent high temperature stability and low impedance is obtained.

The boiling point of the solvent of the electrolyte is 200°C or more, the conductivity at measuring temperature of 30°C of the electrolyte is 1.0 mS/cm or more, and the spark ignition voltage is 80 V or more. In this constitution, it is effective to prevent the problem of electrolytic capacitor for surface mounting, that is, deformation of appearance due to elevation of capacitor internal pressure caused by heat treatment during surface mounting (both capacitor and substrate exposed to high temperature of soldering). Moreover, since the boiling point of the solvent of the electrolyte is high (vapor pressure is low), defective soldering when mounting is less likely to occur, and further since the conductivity is high, the impedance performance is maintained. Still more, since the spark ignition voltage is sufficiently high, an electrolytic capacitor having a high dielectric strength is obtained.

00720749500

The sealing member is composed by using an elastic rubber. In the solid electrolytic capacitor for surface mounting using this elastic rubber, the adsorbed moisture contained in the electrode foil of capacitor element, separator, solid electrolytic substance and rubber sealing member, or the adsorbed moisture bonded to the inside of the case is evaporated at once at high temperature at the time of surface mounting. As a result, the pressure elevation inside the capacitor is extreme, which may lead to defective air tightness of the capacitor or scattering of sealing member. However, by containing the electrolyte using a solvent of high boiling point (low vapor pressure), the total pressure inside the capacitor can be lowered at the time of mounting. Therefore, by containing the liquid component (herein an electrolytic solution) in addition to the electrolytic substance of solid electrolytic substance type, pressure elevation inside the capacitor can be suppressed, and defective soldering and others can be improved.

Examples of solvent of electrolyte having a boiling point of 200°C or more include 3-alkyl-1,3-oxazolidine-2-one (more specifically, 3-methyl-1,3-oxazolidine-2-one: boiling point 260°C), 1,3-dialkyl-2-imidazolidinone other than 1,3-dimethyl-2-imidazolidinone (more specifically, 1,3-dimethyl-2-imidazolidinone: boiling point 236°C, 1,3-

004720-44691960

dipropyl-2-imidazolidinone: boiling point 255°C, 1-methyl-3-ethyl-2-imidazolidinone: boiling point 230°C), 1,3,4-trialkyl-2-imidazolidinone (more specifically, 1,3,4-trimethyl-2-imidazolidinone: boiling point 241°C), 1,3,4,5-tetra-alkyl-2-imidazolidinone (more specifically, 1,3,4,5-tetramethyl-2-imidazolidinone: boiling point 249°C), cyclic lactone (more specifically, γ -butyrolactone: boiling point 204°C), polyhydric alcohol (more specifically, ethylene glycol: boiling point 201°C, glycerin: boiling point 290°C), carbonate (more specifically, ethylene carbonate: boiling point 238°C, propylene carbonate: 242°C), and others.

Hereinafter, preferred embodiments of the invention and prior arts as comparative examples are described below while referring to the attached drawings.

Fig. 1 (a) and Fig. 1 (b) are a partial sectional perspective view showing a constitution of an electrolytic capacitor of the invention, and a conceptual view magnifying essential parts of its element. In Fig. 1 (b), the surface is roughened by etching process, and then a dielectric oxide film 11 is formed by oxidation treatment. An anode foil 1 composed of an aluminum foil forming a solid organic conductive material 2 on its surface, and a cathode foil 3 formed by etching an aluminum foil are wound around a separator 4. Or, after roughening the surface by etching process, an anode foil 1 composed of an aluminum

foil forming a dielectric oxide film 11 by oxidation treatment and a cathode foil 3 formed by etching process of aluminum foil are wound through an electrolytic paper 4A. Then by high temperature treatment thereof, the electrolytic paper 4A is treated by any method of carbonization treatment, and a capacitor element 12 or 12A is formed. Between the dielectric oxide film 11 and cathode foil 3, a solid organic conductive material 2 is formed. It is impregnated with an electrolyte 10, and swollen and infiltrated into the solid organic conductive material 2. Thus, the capacitor element 12 or 12A is composed. The capacitor element 12 or 12A is put in a cylindrical aluminum metallic case 8 with a bottom as shown in Fig. 1 (a). Further, the releasing end of the aluminum metallic case 8 is sealed so that a sealing member 7 made of rubber may penetrate through an anode lead 5 and a cathode lead 6 for external lead-out being led out from the anode foil 1 and cathode foil 3 from the sealing member 7. Thus, the side surface of the metallic case 8 is covered with an external tube 9.

Fig. 2 (a) to Fig. 2 (g) show the manufacturing process for manufacturing the anode foil 1 for electrolytic capacitor of the invention in batch. As shown in Fig. 2 (a), an etching foil 22 (Fig. 2 (b)) obtained by etching an aluminum foil 21 is oxidized. In this way, an anode foil 1

organic conductive material is used. Such organic solvent is desired to have a boiling point of 200°C or more. The solvent is preferred to be mainly composed of γ -butyrolactone and/or ethylene glycol. In addition, for the purpose of improving the low temperature characteristic and enhancing the dielectric strength, other organic solvent compatible with γ -butyrolactone and/or ethylene glycol may be mixed as a subsidiary solvent. Nevertheless, the subsidiary solvent is not required to be an organic solvent capable of swelling in an organic conductive material.

As the subsidiary solvent, in addition to the organic solvent with boiling point of 200°C or more mentioned above, the following organic solvents may be used either alone or as a mixed solvent of two or more kinds, that is, polyhydric alcohol system solvents (propylene glycol, diethylene glycol, 1,4-butane diol, polyoxy alkylene polyol), lactone system solvents (γ -valerolactone, δ -valerolactone, 3-ethyl-1,3-oxazolidine-2-one), water, amide system solvents (N-methyl formamide, N,N-dimethyl formamide, N-methyl acetamide), ether system solvents (methylal, 1,2-dimethoxy ethane, 1-ethoxy-2-methoxy ethane, 1,2-diethoxy ethane), nitrile system solvents (acetonitrile, 3-methoxy propionitrile), furane system solvents (2,5-dimethoxy tetrahydrofuran), 2-imidazolidinone system solvents (1,3-dimethyl-2-imidazolidinone), and others.

In the case of mixed solvent, the mixing ratio of the solvent is preferred to be 40 parts by weight of a solvent of which boiling point is less than 200°C in 100 parts by weight of solvent of which boiling point is 200°C or more. If the content of the solvent of which boiling point is less than 200°C is more than 40 parts, the heat resistance is lowered when an electrolytic capacitor is formed for surface mounting, and the defective rate of soldering becomes higher.

Examples of tertiary amine used in the electrolyte of the invention include trialkylamines (trimethylamine, dimethylethylamine, methyldiethylamine, triethylamine, dimethyl n-propylamine, dimethyl isopropylamine, methyl ethyl n-propylamine, methylethyl isopropylamine, diethyl n-propylamine, diethyl isopropylamine, tri-n-propylamine, tri-isopropylamine, tri-n-butylamine, tri-tert-butylamine, etc.), and phenyl group containing amines (dimethyl phenylamine, methylethyl phenylamine, diethyl phenylamine, etc.).

Among them, trialkylamine having a high conductivity is preferred. More preferably, it is preferred to use at least one selected from the group consisting of trimethylamine, dimethylethylamine, methyl diethylamine, and triethylamine, and by the use thereof, a capacitor high in conductivity and having an excellent impedance

performance is obtained.

Examples of compound having alkyl substituent amidine group used in the electrolyte of the invention include imidazole compound, benzoimidazole compound, and alicyclic amidine compound (pyrimidine compound, imidazoline compound). More specifically, it is preferred to use 1,8-diazabicyclo [5,4,0] undecene-7, 1,5-diazabicyclo [4,3,0] nonene-5, 1,2-dimethyl imidazolinium, 1,2,4-trimethyl imidazoline, 1-methyl-2-ethyl-imidazoline, 1,4-dimethyl-2-ethyl imidazoline, 1-methyl-2-heptyl imidazoline, 1-methyl-2-(3' heptyl) imidazoline, 1-methyl-2-dodecyl imidazoline, 1,2-dimethyl-1,4,5,6-tetrahydropyrimidine, 1-methyl imidazole, and 1-methyl benzoimidazole, and when these compounds are used, a capacitor having a high conductivity and excellent impedance performance is obtained.

In the examples of quaternary salt of compound having alkyl substituent amidine group used as the electrolyte is preferred to be a quaternary compound formed by alkyl group or aryl alkyl group with 1 to 11 carbon atoms is preferred, and preferred examples of amidine group are imidazole compound, benzoimidazole compound, and alicyclic amidine compounds (pyrimidine compound, imidazoline compound). Specific preferred examples include 1-methyl-1,8-diazabicyclo [5,4,0] undecene-7, 1-methyl-1,5-diazabicyclo [4,3,0] nonene-5, 1,2,3-trimethyl imidazolinium, 1,2,3,4-

carbon atoms of their polycarboxylic acids (for example, citraconic acid, dimethyl maleic acid), or nitro substitutes (nitrophthalic acid, 3-nitrophthalic acid, 4-nitrophthalic acid), and polycarboxylic acid containing sulfur (for example, thiopropionic acid), monocarboxylic acid, aliphatic monocarboxylic acid with 1 to 30 carbon atoms (for example, formic acid, acetic acid, propionic acid, butyric acid, isobutyric acid, valeric acid, caproic acid, enanthic acid, caprylic acid, perargonic acid, lauric acid, mystyric acid, stearic acid, behenic acid, other saturated carboxylic acid, and acrylic acid, methacrylic acid, oleic acid, and other unsaturated carboxylic acid), aromatic monocarboxylic acid (for example, benzoic acid, o-nitrobenzoic acid, p-nitrobenzoic acid, cinnamic acid, naphthoic acid), and oxycarboxylic acid (for example, salicylic acid, mandelic acid, resorcylic acid). Among these compounds, particularly preferred compounds are those having high conductivity and excellent thermal conductivity such as maleic acid, phthalic acid, cyclohexane carboxylic acid, cyclohexene-1,2-dicarboxylic acid, cyclohexene-1,2-dicarboxylic acid, adipic acid, and benzoic acid.

The ratio of organic acid and base for composing the electrolyte is usually 4 to 11 at the pH of the electrolyte, and preferably 6 to 9. Out of this range, the spark voltage of the electrolyte (dielectric strength) is lowered.

As the electrolytic salt, organic carboxylic acids stable electrically and chemically are desired. Preferred examples of such organic carboxylic acid include maleic acid, phthalic acid, cyclohexane carboxylic acid, cyclohexene-1,2-dicarboxylic acid, cyclohexene-1,2-dicarboxylic acid, adipic acid, and quaternary salt of compound having alkyl substituent amidine group of benzoic acid.

The electrolyte of the electrolytic capacitor of the invention may mix and contain various additives as required. Usable additives include phosphor compounds (phosphoric acid, ester phosphate, etc.), boric acid compounds (boric acid, complex of boric acid and polysaccharides (mannite, sorbit, etc.)), nitro compounds (o-nitrobenzoic acid, n-nitrobenzoic acid, p-nitrobenzoic acid, o-nitrophenol, m-nitrophenol, p-nitrophenol, p-nitroacetophenone, etc.), and others. In the aluminum electrolytic capacitor, mixing of these additives will improve the restoration of aluminum oxide film. As a result, it is preferred because an electrolytic capacitor of high dielectric strength can be formed easily.

As the bar element for the terminal of the electrolytic capacitor of the invention, a material undergoing corrosion preventive treatment may be used. By corrosion preventive treatment of the bar element, electrolytic current can be

suppressed, and the sealing performance may be enhanced. Corrosion preventive treatment of the bar element is preferred to be done on both terminals of anode and cathode, but only either one may be treated. As means of corrosion preventive treatment, anode oxidation treatment in aqueous solution, coating-sintering of metal alkoxide, and coating-sintering of colloidal solution of metal oxide (colloidal solution of silicon dioxide and titanium dioxide) are convenient and preferred.

The sealing member 7 is preferably an elastic material mainly composed of rubber polymer formed of a copolymer of isobutylene, isoprene and divinyl benzene, comprising 0.5 to 20 parts of vulcanizing agent such as peroxide or alkyl phenol formalin resin. In other vulcanizing method using other vulcanizing agent than peroxide or alkyl phenol formalin resin (for example, sulfur vulcanization), the rubber elasticity drops significantly when left over for a long period in the condition of high temperature and high humidity, and sufficient sealing performance is not obtained, and as a result the organic conductive material may oxidize and deteriorate due to invasion of water from outside.

Preferred embodiments of the invention are described below. In the embodiments, a "part" always refers to a "part by weight."

004720-44651560

The composition of the electrolytes used in the embodiments of the invention and in comparative examples is as follows. As the index of hydrogen ion concentration of the base of the electrolyte or the hydroxide of the base in an aqueous solution, the pH is expressed as a note. The pH is defined in the formula: $\text{pH} = -\log [\text{hydrogen ion concentration}]$. Therefore, if the pH is 13 or less, it means that the hydrogen ion concentration is 1.0×10^{-13} mol/dm³ or more. Besides, an aluminum foil having a dielectric oxide film formed on the surface at voltage of 500 V was immersed in the electrolyte (temperature 30°C). In this state, the spark ignition voltage of electrolyte (that is, the dielectric strength of electrolyte) observed by constant voltage-current elevation at constant current of 2.0 mA/cm² and the conductivity (measuring temperature 30°C) are shown.

Electrolyte A

γ -butyrolactone (100 parts), mono-1,2,3,4-tetramethyl imidazolinium phthalate (30 parts) [note: pH = 11.2], o-nitrobenzoic acid (1 part), monobutyl ester phosphate (1 part), boric acid (2 parts), and mannite (2 parts) were mixed and dissolved.

The spark voltage was 85 V, and the conductivity was 9.0 mS/cm.

THE BATTLE OF BULGE

THE BATTLE OF BULL RUN

THE BATTLE OF BULL RUN

THE BATTLE OF BULL RUN

THE BATTLE OF BULL RUN

THE BATTLE OF BULL RUN

THE BATTLE OF BULL RUN

THE BATTLE OF BULL RUN

The spark voltage was 79 V, and the conductivity was 11.5 mS/cm.

The sealing members of rubber used in the embodiments of the invention and comparative examples are as follows.

Sealing member A [vulcanization by peroxide]

It was vulcanized and formed by mixing 30 parts of rubber polymer composed of a copolymer of isobutylene, isoprene and divinyl benzene, 20 parts of carbon, 50 parts of inorganic filler, and 2 parts of dicumyl peroxide as a vulcanizing agent. The hardness of the sealing member after forming was measured on the surface portion at the side contacting with the capacitor element between two rubber holes for penetrating a lead, and the surface of the portion contacting with the lead wire side of the rubber hole inside. As a result, the IRHD (international rubber hardness degree) was respectively 67 IRHD and 66 IRHD.

Sealing member B [vulcanization by resin]

It was vulcanized and formed by mixing 30 parts of rubber polymer composed of a copolymer of isobutylene and isoprene, 20 parts of carbon, 50 parts of inorganic filler, and 2 parts of alkyl phenol formalin resin as vulcanizing agent. The hardness of the sealing member after forming

was measured on the surface portion at the side contacting with the capacitor element between two rubber holes for penetrating a lead, and the surface of the portion contacting with the lead wire side of the rubber hole inside. As a result, the IRHD (international rubber hardness degree) was respectively 77 IRHD and 76 IRHD.

(Embodiment 1)

An anode aluminum foil and a cathode aluminum foil were wound around an electrolytic paper containing Manila hemp fibers (density 0.55 g/cm^3 , thickness $50 \text{ }\mu\text{m}$). Thus prepared winding type aluminum electrolytic capacitor was kept at temperature of 300°C for 30 minutes, and the electrolytic paper was carbonized. Then, this capacitor element was immersed in a water-ethanol solution containing ethylene dioxythiophen and ferric sulfate, and lifted, and polymerized (10 minutes at 105°C), and this process was repeated 10 times. The solid organic conductive material layer composed of polyethylene dioxythiophen thus polymerized chemically was formed on the electrode foils and between electrode foils. Consequently, the capacitor element was washed in water, and dried. Further, electrolyte A was impregnated in this capacitor element. As a result, an aluminum electrolytic capacitor element with rated voltage of 50 V and electrostatic capacity of

390 μF was obtained. This capacitor element was put in an aluminum metallic case together with sealing member A, and the opening was sealed by curling process. Thus, an aluminum electrolytic capacitor was composed (size: $\phi 13 \text{ mm} \times \text{L } 20 \text{ mm}$).

(Embodiment 2)

A glass fiber nonwoven cloth (density 0.13 g/cm^3 , thickness $50 \mu\text{m}$), an anode aluminum foil, and a cathode aluminum foil were immersed in a water-ethanol solution containing pyrrole and ammonium persulfate, and lifted, dried and polymerized (10 minutes at 105°C), and this process was repeated three times. Thus, a chemically polymerized polypyrrole was formed. Then, washing in water and drying, the separator made conductive by the chemically polymerized polypyrrole, and the anode aluminum foil and cathode aluminum foil having the chemically polymerized polypyrrole formed on the surface were obtained. Then, through this conductive separator, the anode aluminum foil and cathode aluminum foil having the chemically polymerized polypyrrole formed on the surface were wound, and a capacitor element was formed. It was further immersed in soluble sulfonated polyaniline solution at concentration of 10 wt.%, impregnated at reduced pressure, lifted, and dried. Thus, the residual dried sulfonated polyaniline was formed

00016944-024400

It was further immersed in soluble sulfonated polyaniline solution at concentration of 10 wt.%, impregnated at reduced pressure, lifted, and dried at a temperature below the melting point of the 7,7,8,8-tetracyanoquinodimethane complex. Thus, the residual dried sulfonated polyaniline was formed between the anode aluminum foil and cathode aluminum foil having the 7,7,8,8-tetracyanoquinodimethane complex. Thus, the electric bonding between the electrode foils was reinforced. Still more, this capacitor element was impregnated in electrolyte A. As a result, an aluminum electrolytic capacitor element with rated voltage of 50 V and electrostatic capacity of 390 μ F was obtained. This capacitor element was put in an aluminum metallic case together with sealing member A, and the opening was sealed by curling process. Thus, an aluminum electrolytic capacitor was composed (size: ϕ 13 mm \times L 20 mm).

(Embodiment 4)

An electrolytic capacitor was prepared in the same manner as in embodiment 1 except that electrolyte B was used as the electrolyte in embodiment 1 of the invention.

(Embodiment 5)

An electrolytic capacitor was prepared in the same manner as in embodiment 1 except that electrolyte C was

used as the electrolyte in embodiment 1 of the invention.

(Embodiment 6)

An electrolytic capacitor was prepared in the same manner as in embodiment 1 except that electrolyte D was used as the electrolyte in embodiment 1 of the invention.

(Embodiment 7)

An electrolytic capacitor was prepared in the same manner as in embodiment 1 except that sealing member B was used as the sealing member in embodiment 1 of the invention.

(Embodiment 8)

An electrolytic capacitor was prepared in the same manner as in embodiment 1 except that pyrrole was used instead of ethylene dioxythiophen in embodiment 1 of the invention.

(Embodiment 9)

An electrolytic capacitor was prepared in the same manner as in embodiment 1 except that aniline was used instead of ethylene dioxythiophen in embodiment 1 of the invention.

(Embodiment 10)

An electrolytic capacitor was prepared in the same manner as in embodiment 1 except that a mixture of iron p-toluene sulfonate and iron dodecyl benzene sulfonate was used instead of ferric sulfate, and that water-methanol solution was used instead of water-ethanol solution in embodiment 1 of the invention.

(Embodiment 11)

An electrolytic capacitor was prepared in the same manner as in embodiment 1 except that a mixture of ammonium persulfate and hydrogen persulfate water was used instead of ferric sulfate in embodiment 1 of the invention.

(Comparative example 1)

An anode aluminum foil and a cathode aluminum foil were wound around an electrolytic paper containing Manila hemp fibers (density 0.55 g/cm^3 , thickness $50 \text{ }\mu\text{m}$). Thus a capacitor element was prepared. This capacitor element was impregnated in electrolyte A, and an aluminum electrolytic capacitor element with rated voltage of 50 V and electrostatic capacity of $390 \text{ }\mu\text{F}$ was obtained. This capacitor element was put in an aluminum metallic case together with sealing member A. Then the opening was sealed by curling process. Thus, an aluminum electrolytic capacitor was composed (size: $\phi 13 \text{ mm} \times \text{L } 20 \text{ mm}$).

(Comparative example 2)

An electrolytic capacitor was prepared in the same manner as in embodiment 1 except that electrolyte A was not impregnated in embodiment 1 of the invention.

(Comparative example 3)

An anode aluminum foil and a cathode aluminum foil were wound around an electrolytic paper containing Manila hemp fibers (density 0.55 g/cm^3 , thickness $50 \text{ }\mu\text{m}$). Thus a capacitor element was prepared. This capacitor element was kept at temperature of $300 \text{ }^\circ\text{C}$ for 30 minutes, and the electrolytic paper was carbonized. Then this element was immersed in 7,7,8,8-tetracyanoquinodimethane complex in molten state and impregnated at reduced pressure. By cooling, a 7,7,8,8-tetracyanoquinodimethane complex layer was formed directly between the electrodes. Thus, an aluminum electrolytic capacitor element with rated voltage of 50 V and electrostatic capacity of $390 \text{ }\mu\text{F}$ was obtained. This capacitor element was put in an aluminum metallic case together with sealing member A, and the opening was sealed by curling process. Thus, an aluminum electrolytic capacitor was composed (size: $\phi 13 \text{ mm} \times \text{L } 20 \text{ mm}$).

(Comparative example 4)

001120-44691960

An anode aluminum foil and a cathode aluminum foil were wound around a glass fiber nonwoven cloth (density 0.13 g/cm³, thickness 50 μm), and the obtained aluminum electrolytic capacitor element was immersed in an aqueous solution of manganese nitrate, lifted, and pyrolyzed (10 minutes at 300°C), and this process was repeated 10 times, and a manganese dioxide layer which is a solid inorganic conductive material was directly formed between the electrodes. This capacitor element was impregnated in electrolyte A. Thus, an aluminum electrolytic capacitor element with rated voltage of 50 V and electrostatic capacity of 390 μF was obtained. This capacitor element was put in an aluminum metallic case together with sealing member A, and the opening was sealed by curling process. Thus, an aluminum electrolytic capacitor was composed (size: φ13 mm×L 20 mm).

(Comparative example 5)

An electrolytic capacitor was prepared in the same manner as in comparative example 1 except that carbon fabric weaving carbon fibers was used instead of the electrolytic paper in comparative example 1.

(Comparative example 6)

An electrolytic capacitor was prepared in the same

manner as in comparative example 1 except that glass fiber nonwoven cloth coated with water dispersion type colloidal graphite was used instead of the electrolytic paper in comparative example 1.

Table 1 shows results of comparison of initial characteristics (electrostatic capacity, impedance leak current) and number of shorting troubles during aging process in aluminum electrolytic capacitors in embodiments 1 to 11 of the invention and comparative examples 1 to 6.

In each material, the number of samples was 20, and the initial characteristic (except for shorting troubles) is expressed by the average of 20 samples.

Table 1

	Electro- static capacity (μ F) f=120 Hz	Leak current (μ A) at rated voltage, 2 min	Number of shorting troubles during aging	Impedance (m Ω) f=400 kHz
Embodiment 1	390	92	0	10
Embodiment 2	390	90	0	11
Embodiment 3	370	93	0	11
Embodiment 4	393	90	0	12
Embodiment 5	385	88	0	22
Embodiment 6	380	180	0	10
Embodiment 7	390	89	0	11
Embodiment 8	390	89	0	12
Embodiment 9	384	90	0	13
Embodiment 10	360	91	0	13
Embodiment 11	380	91	0	11
Comparative example 1	395	70	0	41
Comparative example 2	360	1000 or more	15	15
Comparative example 3	385	1000 or more	18	13
Comparative example 4	385	195	2	18
Comparative example 5	380	170	0	30
Comparative example 6	390	1000 or more	17	25

As clear from Table 1, the electrolytic capacitors in embodiments 1 to 11 of the invention is extremely small in impedance as compared with the electrolytic capacitor composed only of electrolyte in comparative example 1.

In the aluminum electrolytic capacitor lowered in resistance by using carbon fabric weaving carbon fibers as means of making the separator conductive in comparative example 5, the impedance is improved as compared with comparative example 1, but the impedance is larger than in the electrolytic capacitors in embodiments 1 to 11.

In the electrolytic capacitors in the comparative examples, that is, in the aluminum electrolytic capacitor not having electrolyte using only conductive high polymer (polyethylene dioxythiophen layer) in comparative example 2, in the aluminum electrolytic capacitor not having electrolyte using only organic semiconductor (7,7,8,8-tetracyanoquinodimethane complex layer) in comparative example 3, and in the aluminum electrolytic capacitor lowered in resistance by applying water-dispersion type colloidal graphite as the conductive means of separator in comparative example 6, shorting troubles (shorting between electrodes due to lack of dielectric strength) occurred in all samples during aging process for applying a direct voltage of 63 V at temperature of 85°C.

In the aluminum electrolytic capacitor using manganese

dioxide which is a solid inorganic conductive material, instead of solid organic conductive material, in comparative example 4, although the impedance is excellent, since the conductive material is inorganic, the electrolyte, which is an organic matter, is hardly diffused, and the restoration performance of the dielectric oxide film was not assured sufficiently. Accordingly, slight shorting troubles occurred during aging.

As explained herein, the invention presents, in a simple process, electrolytic capacitors having excellent characteristics, such as excellent impedance characteristic, small leak current, superior reliability, and high dielectric strength. Of the embodiments of the invention, in embodiment 6 of the invention using electrolyte D, since the spark ignition voltage of electrolyte is below 80 V, the dielectric strength is not sufficient, and the leak current value tends to be higher as compared with other embodiments although shorting did not occur during aging. Therefore, to express the effects of the invention sufficiently in the aspects of dielectric strength and leak current, the spark ignition voltage of the electrolyte is preferred to be 80 V or more.

Of the embodiments of the invention, in embodiment 5 of the invention using electrolyte C, since the conductivity

Table 2

	Appearance of sealing member surface after 1000 hours of humidity resistance test at 60°C, 95% RH
Embodiment 1	No abnormality
Embodiment 2	No abnormality
Embodiment 3	No abnormality
Embodiment 4	No abnormality
Embodiment 5	No abnormality
Embodiment 6	Electrolyte leak in 2 samples
Embodiment 7	No abnormality
Embodiment 8	No abnormality
Embodiment 9	No abnormality
Embodiment 10	No abnormality
Embodiment 11	No abnormality

As clear from Table 2, extreme abnormality was not observed in any embodiment. However, in embodiment 6 using electrolyte D, since the base of the electrolytic material is a base of strong basicity with hydrogen ion concentration of less than 1.0×10^{-13} mol/dm³, in the long-term test in complex environments of high temperature and high humidity, the sealing member (sealing portion) is likely to be damaged by the effects of the base of strong basicity, and, as a result, electrolyte leak was observed

in two samples. The electrolyte leaks from the lead. In order to express the effects of the invention sufficiently in the aspect of reliability, in the base for composing the electrolytic substance, the concentration of the base or the hydroxide of the base is preferred to be 1 wt.% or more, and when the measuring temperature is 30°C, the hydrogen ion concentration of the base or the hydroxide of the base in aqueous solution is preferred to be selected at 1.0×10^{-13} mol/dm³ or more.

According to the method of embodiments 1 to 11 of the invention and comparative examples 2 and 3, again, aluminum electrolytic capacitor elements with rated voltage of 6.3 V and electrostatic capacity of 1000 μF were obtained. This capacitor element was put in a aluminum metallic case together with the sealing member A. Then the opening was sealed by curling process. Consequently, a resin seat plate made of polyphenylene sulfide was mounted. As a result, an aluminum electrolytic capacitor of vertical surface mounting type was fabricated (size: φ10 mm × L 10 mm). Thus composed aluminum electrolytic capacitor of surface mounting type was mounted on a glass epoxy substrate (2 mm thick) by using cream solder (Sn-Pb eutectic composition). By passing through a reflow furnace for infrared and hot air treatment (peak temperature 240°C, exposure time to temperature of 200 °C or more of 50

